

IN THE CLAIMS

Please substitute claim 1, as provided below, for claim 1 currently in the present application.

1. (2X Amended) A method of refilling an ink bag for use in an ink jet recorder, the ink bag being initially filled with ink through a first opening in the bag that is sealed after the ink bag is initially filled, said method comprising the steps of:

removing the ink bag from the ink jet recorder;

positioning the ink bag;

inserting an ink needle into a second opening in the ink bag that is different than the first opening through which the ink bag is initially filled with ink, said second opening comprising an ink supply port selectively engageable with an ink jet recorder; and

charging the ink bag only through the second opening with a specified quantity of ink.

Please add claims 3 – 10 as provided below:

3. A method of refilling an ink bag for use in an ink jet recorder, the ink bag having a flexible bag portion having an interior and being initially filled with ink through a first opening in the bag that is sealed after the ink bag is initially filled, said method comprising the steps of:

removing the ink bag from the ink jet recorder;

positioning the ink bag;

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inserting an ink needle into a second opening in the ink bag that is different than the first opening through which the ink bag is initially filled with ink, the second opening comprising an ink supply port selectively engageable with an ink jet recorder, wherein the ink needle is inserted into the interior of the flexible bag portion of the ink bag; and

charging the ink bag only through the second opening with a specified quantity of ink.

4. A method of refilling an ink bag for use in an ink jet recorder, the ink bag being initially filled with ink through a first opening in the bag that is sealed after the ink bag is initially filled, said method comprising the steps of:

removing the ink bag from the ink jet recorder;

positioning the ink bag;

inserting an ink needle into a second opening in the ink bag that is different than the first opening and that is located linearly opposite of the first opening and through which the ink bag is initially filled with ink, the second opening comprising an ink supply port selectively engageable with an ink jet recorder, the ink needle being inserted into the second opening along the linear line between the first and second openings; and

charging the ink bag only through the second opening with a specified quantity of ink.

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5. A method of manufacturing an ink cartridge, comprising the steps of:
- (a) providing an ink bag including an outlet side and an inlet side, said outlet side having a port, said inlet side being open;
 - (b) hanging said ink bag with said port facing downward;
 - (c) charging a predetermined amount of ink to an ink level into said ink bag via said inlet side; and
 - (d) sealing said inlet side at a position below the ink level by heat welding.
6. The method according to claim 5, wherein said steps of charging and sealing are conducted under a depressurized condition.
7. The method according to claim 5, wherein said step of sealing includes:
- sealing said inlet side at a first portion by heat welding; and
 - sealing said inlet side at a second position below said first position by heat welding.
8. The method according to claim 5, further comprising the step of:
- cutting said inlet side subsequently to said step (d).

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9. The method according to claim 5, wherein said step (d) includes sealing said inlet side at a position slightly lower than an ink level.

10. The method according to claim 5, further comprising the step of:
contacting a plate with a surface of said ink bag between said outlet and inlet sides prior to said step (d).
